


Date: Thursday, 8/3/2006 8:10:18 AM
 User: Chantal-Lavoie

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BUSHING
Job Number : 28087	
Estimate Number : 12497	
P.O. Number : N/A	Part Number : D26179
This Issue : 8/3/2006 S.O. No. : N/A	Drawing Number : D2617 REV E
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : E. Preliminary
Previous Run : N/A	Material : N/A
Written By : 	Due Date : 8/10/2006 Qty: 10 Um: Each
Checked & Approved By : _____	
Comment : Est A 06.07.25 New Issue KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6R0500	6061-T6 Round Bar .500"
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Comment: Qty.: 0.0420 f(s)/Unit Total : 0.4200 f(s)

Delrin Round Bar .50"

Material: Delrin Round Bar Ø0.500"

(M-DELIN-R0.500)

Identify as D2617

Batch: M101421

06/08/08 10

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: 1-TURN AS PER FOLIO FA & DWG D2617,

FOLIO REV: N/A

DWG REV: E

2-DEBURR AS REQUIRED

N/A Machined Manually

06/08/08 10

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

06/08/08 10

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

J.F. 06/08/09 10

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr break all unmarked sharp edges 0.005 to 0.010

06/08/08 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Thursday, 8/3/2006 8:10:18 AM
User: Chantal Lavoie

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 28087

Part Number: D26179

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BG 06.08.09 10

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 53

AS
LB 06/08/14 (10)

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



CL 06/08/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector


NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

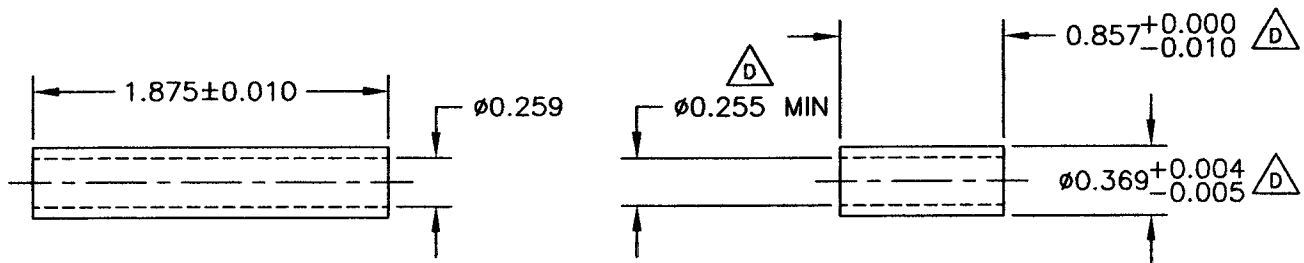
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

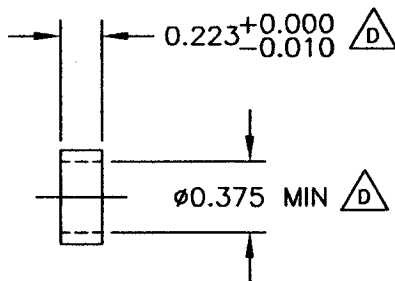
PRELIMINARY ISSUE

DESIGN BW	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2617	REV. E SHEET 1 OF 1
DATE 06.07.25	TITLE BUSHING		SCALE 1:1
A	96.10.08	NEW ISSUE	
B	97.05.08	0.875 WAS 1.125	
C	97.06.04	0.369 DIA WAS 0.375	
D	01.07.04	ADD MAT'L SPEC AND TOL./DIM. NOTE CORRECT TOL. (NCR779), ADD D2617-7	
E	06.07.25	ADD D2617-9	

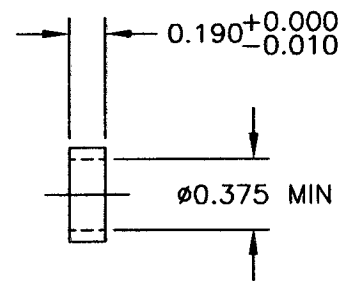


D2617-1 (MAT'L SPEC: SEE NOTE 1)

D2617-3 (MAT'L SPEC: SEE NOTE 1)
D2617-7 (DIM'S SAME AS D2617-3,
FOR MAT'L SPEC: SEE NOTE 3)



D2617-5 (MAT'L SPEC: SEE NOTE 2)



D2617-9 (MAT'L SPEC: SEE NOTE 2)

NOTES:

- 1) MATERIAL FOR D2617-1/-3: 5052-H32 (QQ-A-225/7 OR WW-T-700/4)
OR 6061-T6 (QQ-A-225/8, QQ-A-200/8, OR WW-T-700/6)
(REF. DART SPEC. M5052H32R0.375)
- 2) MATERIAL FOR D2617-5/-9: 5052-H32 (QQ-A-225/7 OR WW-T-700/4)
OR 6061-T6 (QQ-A-225/8, QQ-A-200/8, OR WW-T-700/6)
(REF. DART SPEC. M5052H32R0.500)
- 3) MATERIAL FOR D2617-7: DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELIN-R0.375)
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) FINISH: ACID ETCH, ALODINE PER QSI 005 4.1
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES

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DART AEROSPACE LTD		Work Order:	28081
Description: <i>Bushing</i>		Part Number:	2617-9
Inspection Dwg: <i>D2617</i> Rev: <i>E</i>		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

First Article

Prototype

[illegible]

Measured by:		Audited by:	S.G	Prototype Approval:	
Date:	06/08/08	Date:	06/08/09	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	